Dart Aerospace Ltd.

Date: Friday, 9/14/2007 2:01:23 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LUG WELDMENT
Job Number	: 34676		
Estimate Number	: 12116		
P.O. Number	: N/A	Part Number	: D335313
This Issue	: 9/14/2007 S.O. No. : N/A	Drawing Number	: D3353 REV. A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: NA Type : LARGE FAB ASSY	Drawing Revision	: A
Previous Run	: 30454	Material	: N/A
Written By	:	Due Date	: 9/30/2007 Qty: 4 Um: Each
Checked & Approved By	: 07.09.17		
Comment	: est rev A 06.01.26 new issue EC		

MAT ? 1

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	M1018TR1250W109	1010-1025 Steel Tubing

Comment: Qty.: 0.9188 f(s)/Unit Total : 3.6750 f(s)
AISI 1018-1025 mild steel seamless round tubing
1.250" od X 0.109" wall batch: M106091 08 01 04

2.0	BAND SAW	BAND SAW

Comment: BAND SAW
Cut blank 10.50" long as per dwg D3353 08 01 04

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE

Comment: CONVENTIONAL MILLING MACHINE
1- Drill & tap as per dwg D3353
2-Deburr as per dwg D3353 08 01 10

4.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP 08/01/10 (4X)

5.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: 490 8/1/11 SD (4X)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes (No) **DQA:** D **Date:** 08/01/11

QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Date: Friday, 9/14/2007 2:01:23 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** LUG WELDMENT

Job Number: 34676 **Part Number:** D335313

Job Number:

Seq. #:	Machine Or Operation:	Description :
6.0	QC21	FINAL INSPECTION/W/O RELEASE

(4)

Comment: FINAL INSPECTION/W/O RELEASE

Done 8/9/11

Job Completion

4 08.09.11

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	34676
Description: Tubing	Part Number:	D3353-13
Inspection Dwg: D3353 **Rev:** A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

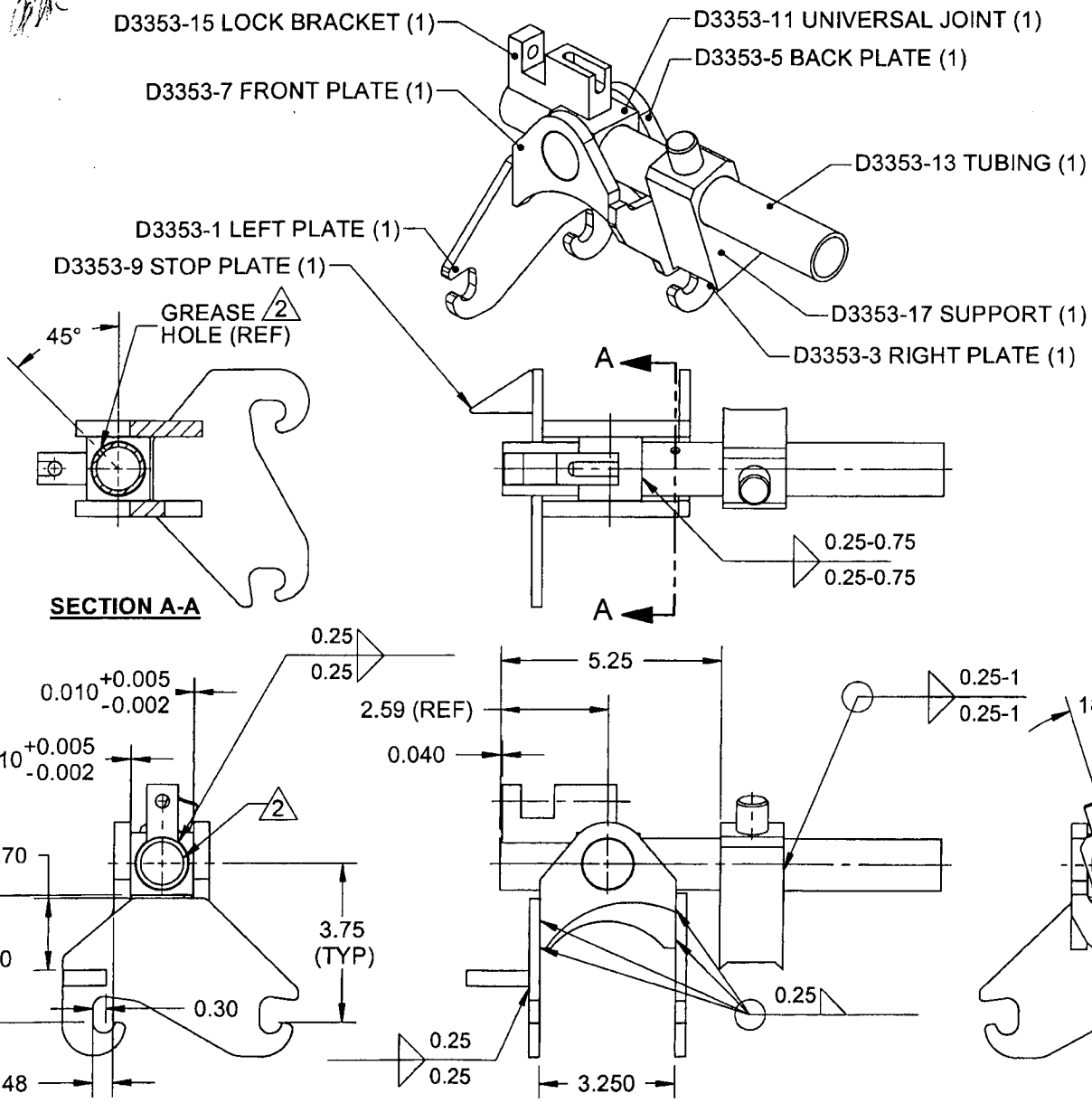
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
10.50	+/-0.030	10.502	—			
4.125	+/-0.010	4.125	—			
Ø0.213	+0.005/-0.001	.213	—			
1/4-28 UNF	N/A	1/4 x 28	—			
Ø1.25	+/-0.010	1.253	—			
Ø0.109	+/-0.010	.110	—			
Ø1.032	+/-0.010	1.032	—			

Measured by:		Audited by:		Prototype Approval:	N/A
Date:	08 01 10	Date:	08/08/10	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.03.28	New Issue	KJ/JLM	

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
RF	RF		
CHECKED	APPROVED	DRAWING NO. D3353	REV. A SHEET 1 OF 10
DATE 04.12.14		TITLE LUG WELDMENT	SCALE 1:4
A	04.12.14	NEW ISSUE	

RELEASED
35/35/04



D3353-041 LUG WELDMENT

NOTES:

1) WELD PER DART QSI 004
2) COVER INSIDE HOLES PRIOR PAINTING
3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES
6) BREAK ALL SHARP EDGES 0.010 TO 0.020

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DATE 04.12.14		TITLE LUG WELDMENT	SCALE 1:4

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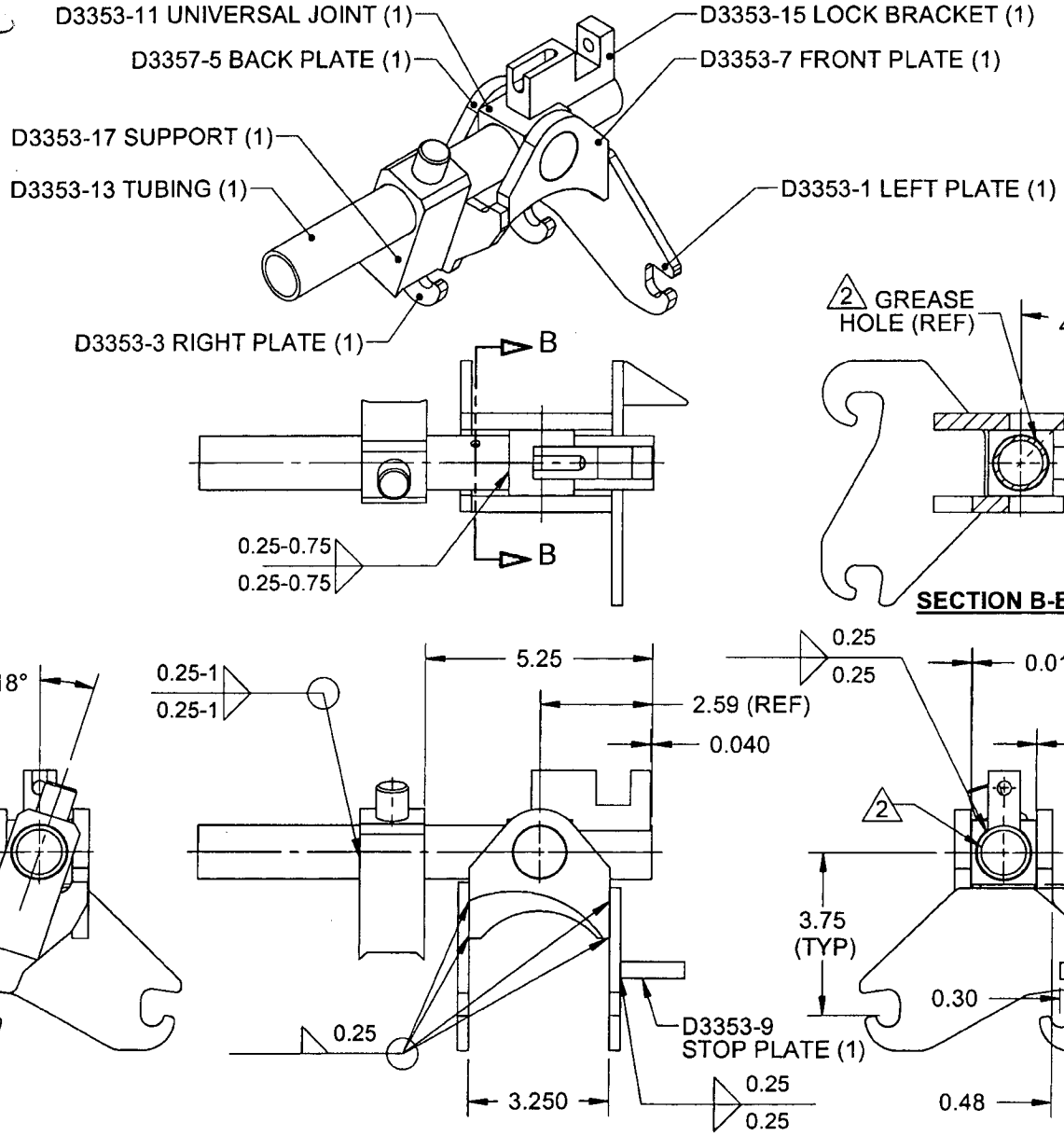
04/02/14



D3353-042 LUG WELDMENT

NOTES:

1) WELD PER DART QSI 004
2) COVER INSIDE HOLES PRIOR PAINTING
3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES
6) BREAK ALL SHARP EDGES 0.010 TO 0.020

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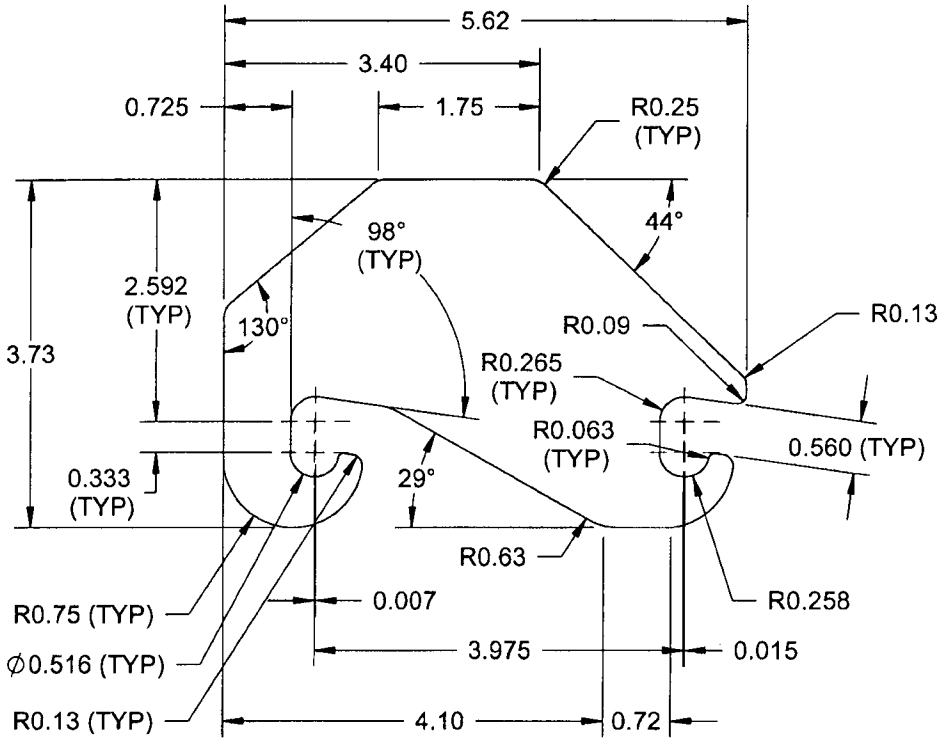
DATE 04.12.14		TITLE LUG WELDMENT	SCALE 1:2

RELEASED
01/05/14



D3353-1 LEFT PLATE

NOTES:

1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 3 GAUGE (0.250 THICK)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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DATE 04.12.14		TITLE LUG WELDMENT	SCALE 1:1

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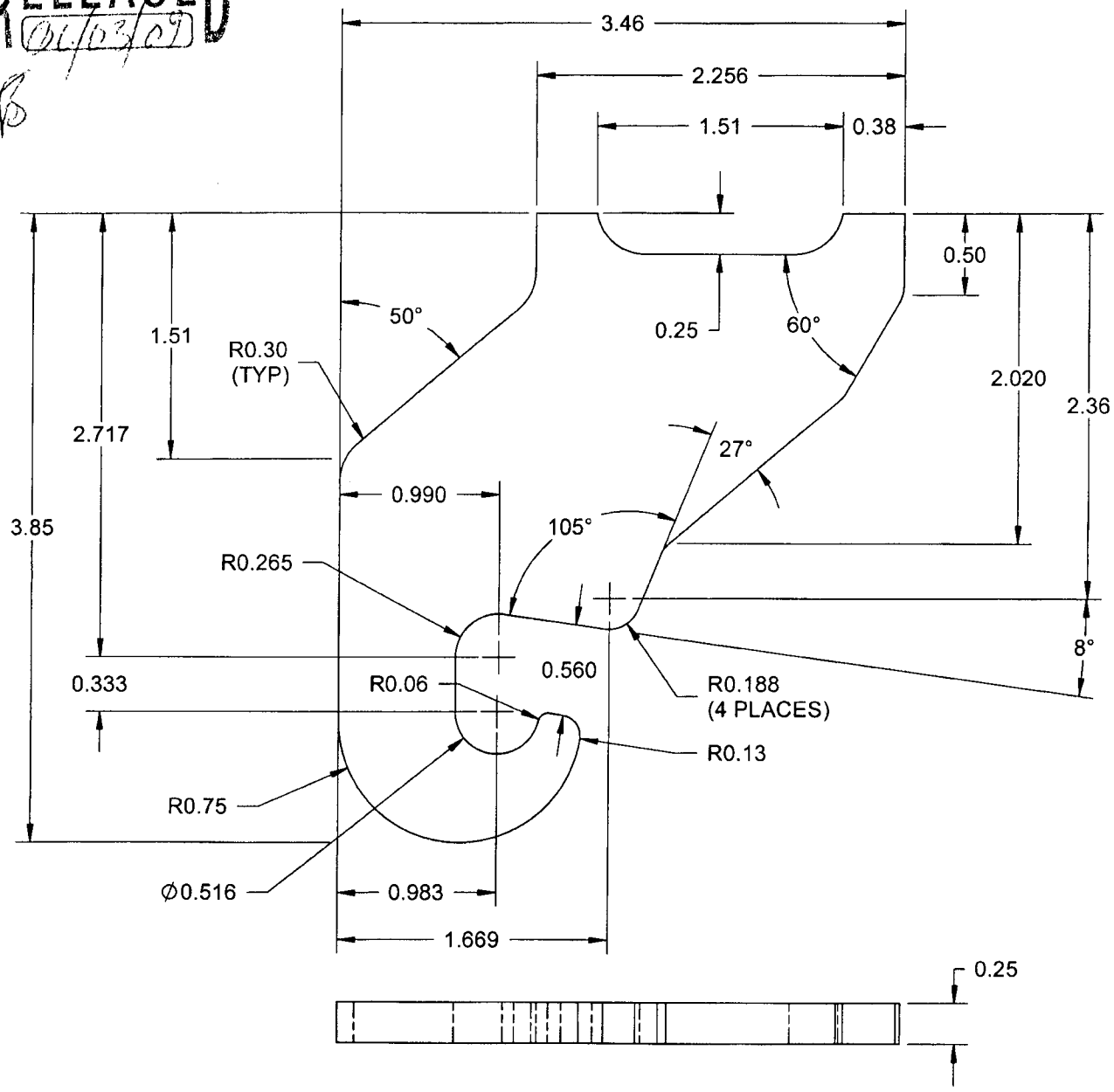
01/03/07



D3353-3 RIGHT PLATE

NOTES:

1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A108 OR CSA G40.21, 38W/44W/50W/60W/70W SERIES STEEL 3 GAUGE (0.250 THICK)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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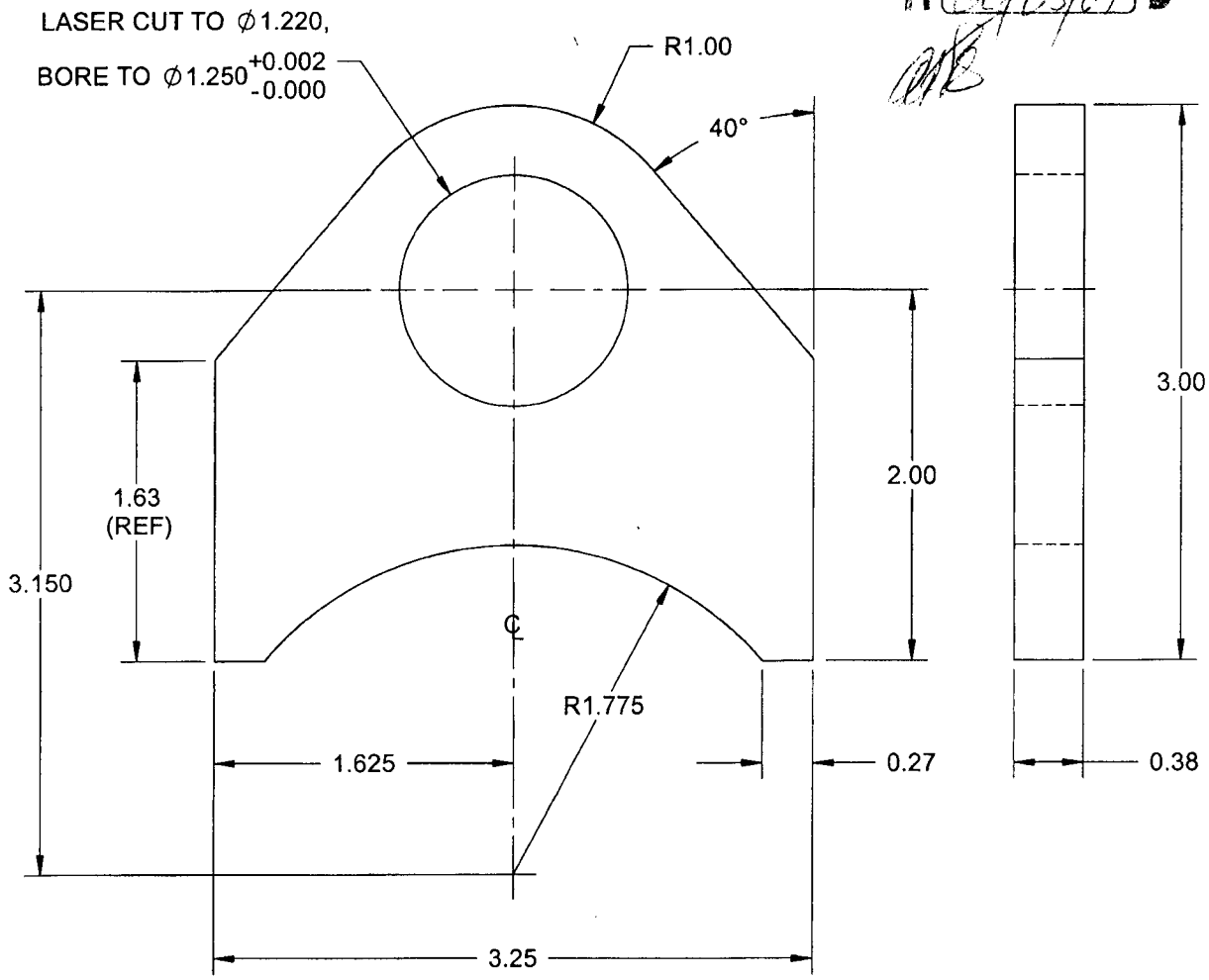
DATE 04.12.14		TITLE LUG WELDMENT	SCALE 1:1

RELEASED
36/03/04



D3353-5 BACK PLATE

NOTES:

1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A108 OR CSA G40.21, 38W/44W/50W/60W/70W SERIES STEEL 0.375 THICK PLATE
   MIN. ULTIMATE TENSILE STRENGTH = 42 ksi
   MIN. YIELD TENSILE STRENGTH = 28 ksi
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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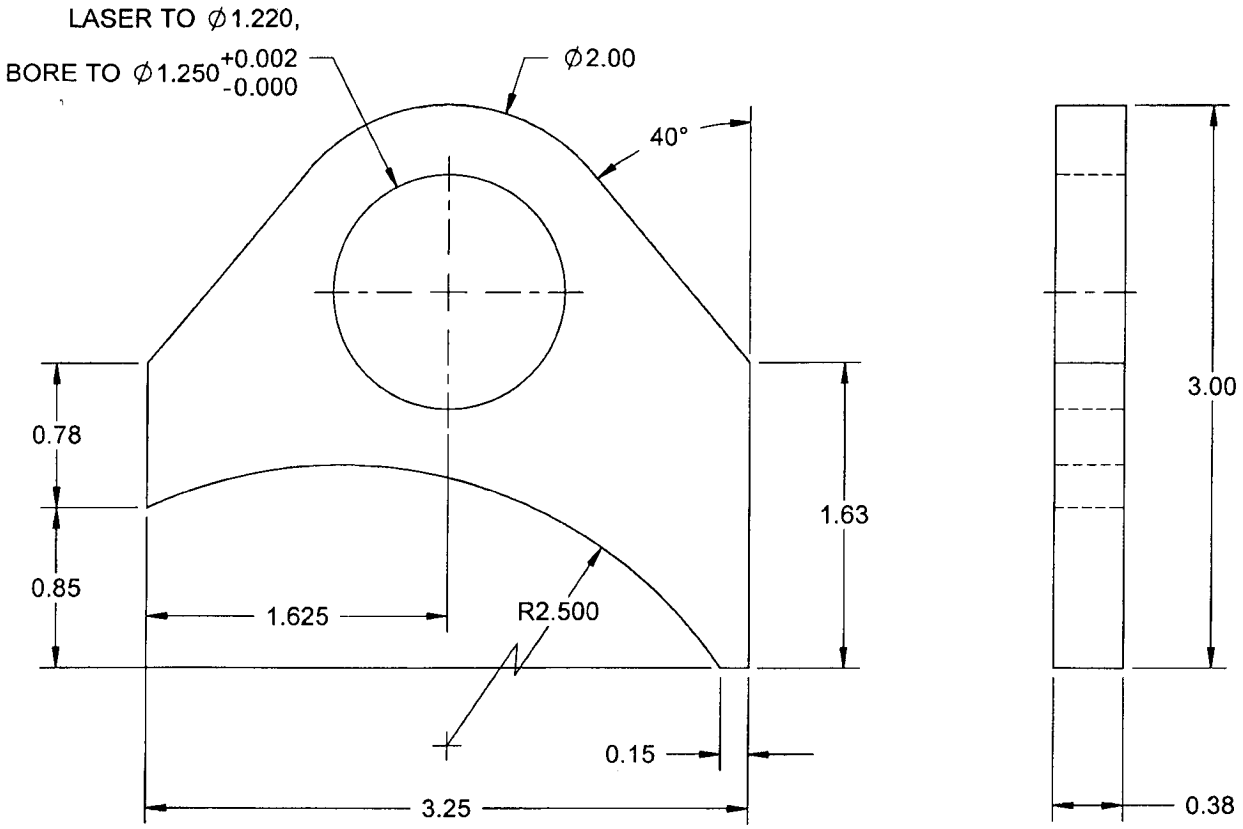
DATE 04.12.14		TITLE LUG WELDMENT	SCALE 1:1

RELEASED
04/10/14



D3353-7 FRONT PLATE

NOTES:

1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A108 OR
CSA G40.21, 38W/44W/50W/60W/70W SERIES
STEEL 0.375 THICK PLATE
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi
MIN. YIELD TENSILE STRENGTH = 28 ksi
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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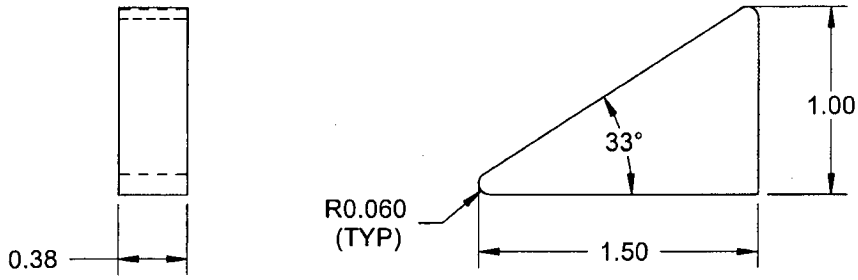
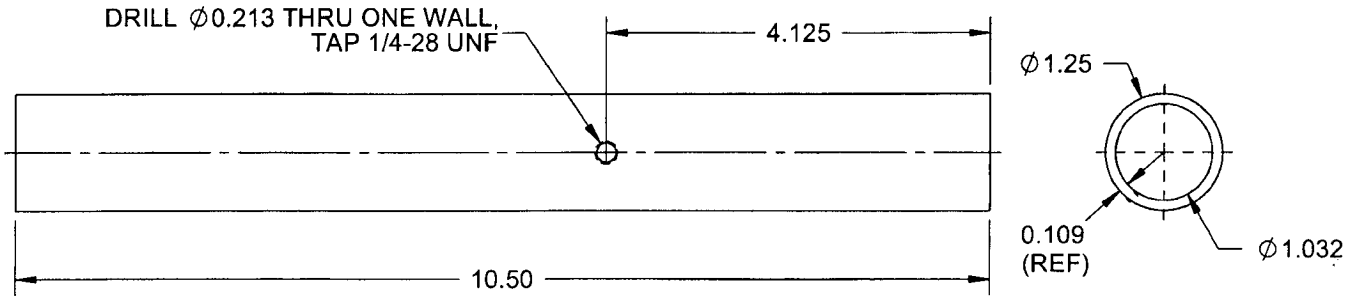
DATE 04.12.14		TITLE LUG WELDMENT	SCALE 1:1

RELEASED



D3353-9 STOP PLATE

1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 0.375 THICK MILD STEEL BAR (REF. DART SPEC. M1010-B)



D3353-13 TUBING

NOTES:

1) MATERIAL: MIL-T-5066 OR ASTM A513-00 MT1020 SRA OR AMS 5075 OR AMS 5077, Ø1.250 x 0.125 WALL, COLD DRAWN STEEL TUBING (REF. DART SPEC. M1020TR1.250W.109)

NOTES:

2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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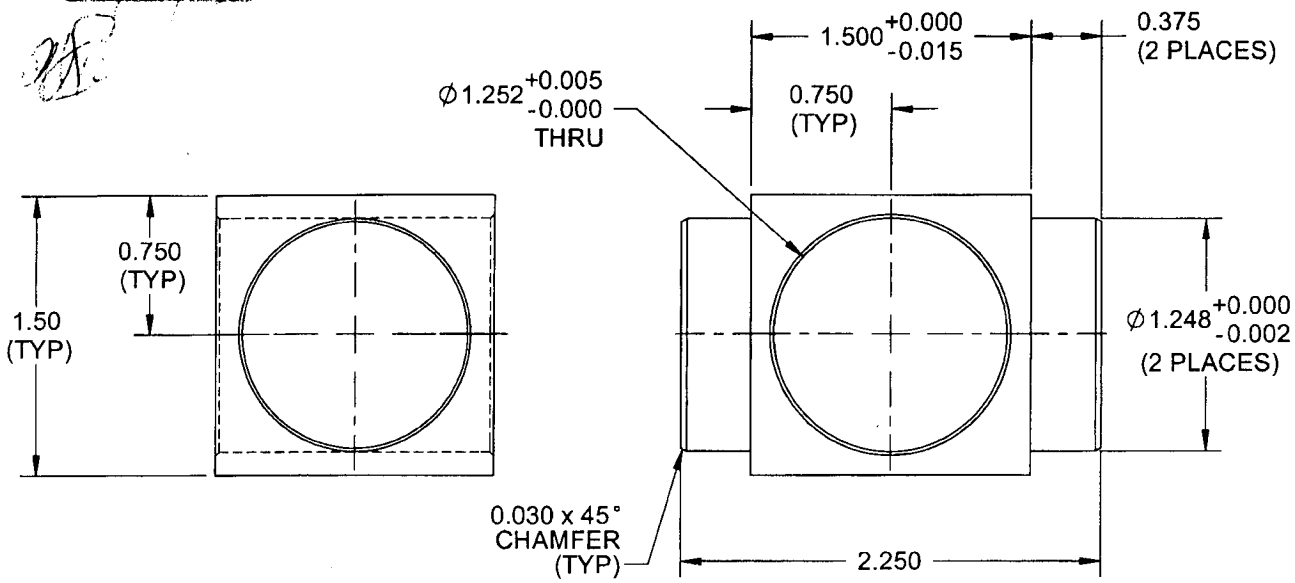
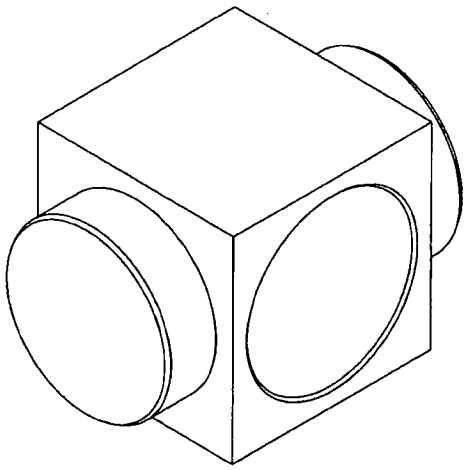
CHECKED	APPROVED	DRAWING NO. D3353	REV. A SHEET 8 OF 10
DATE 04.12.14		TITLE LUG WELDMENT	SCALE 1:1

RELEASED
04/3/09





D3353-11 UNIVERSAL JOINT

NOTES:

1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 1.50 SQUARE MILD STEEL BAR (REF. DART SPEC. M1010-B)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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CHECKED	APPROVED	DRAWING NO. D3353	REV. A SHEET 9 OF 10
DATE 04.12.14		TITLE LUG WELDMENT	SCALE 1:1

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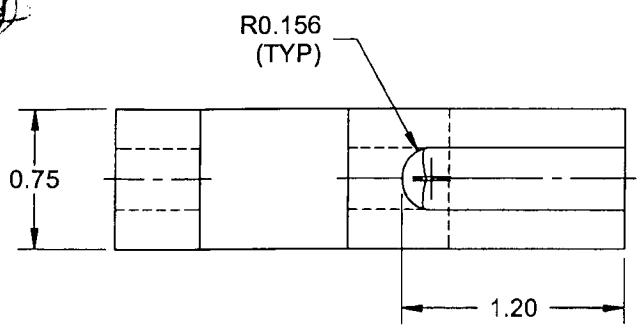
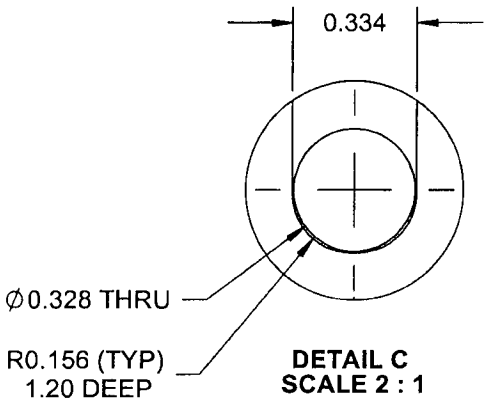
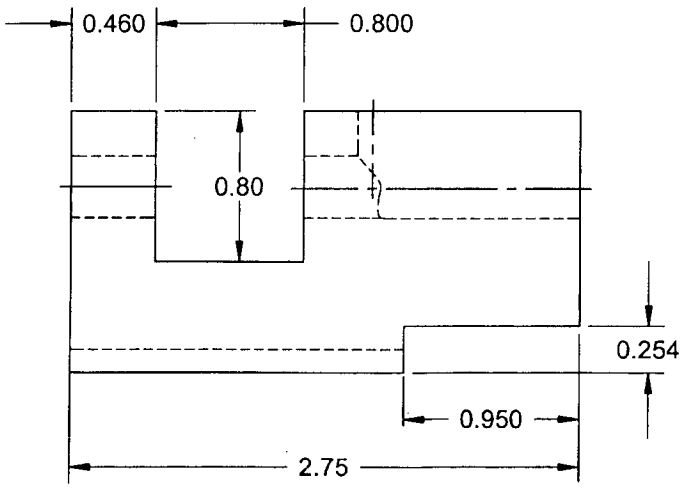
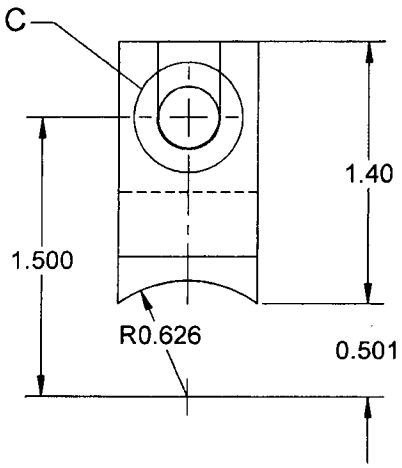




DETAIL C
SCALE 2 : 1

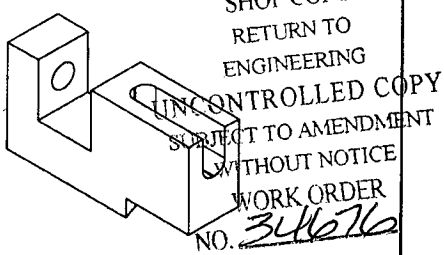




D3353-15 LOCK BRACKET

NOTES:

1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 0.75 THICK MILD STEEL BAR (REF. DART SPEC. M1010-B)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.010 TO 0.020



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ISOMETRIC VIEW
SCALE 1 : 2

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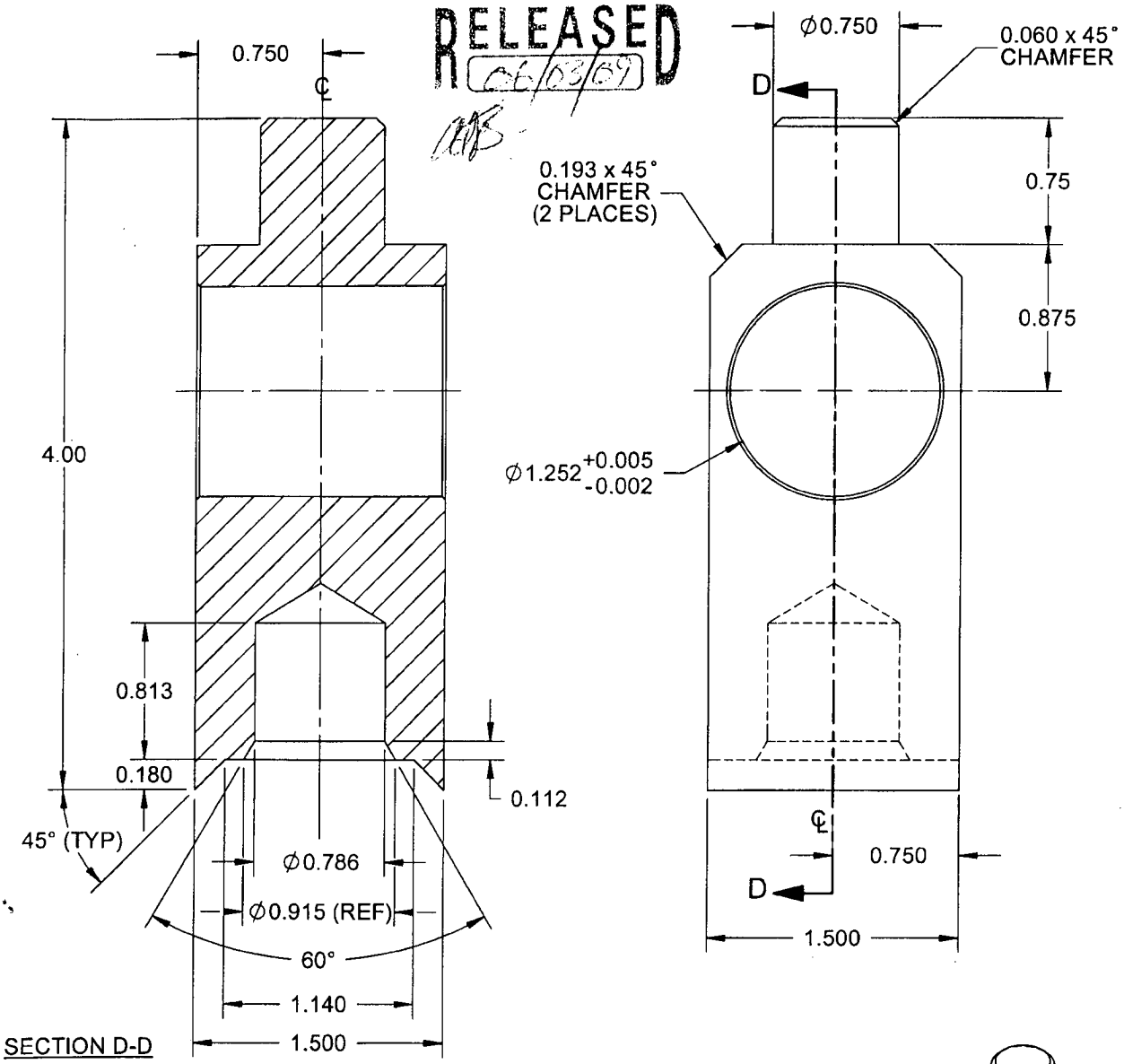
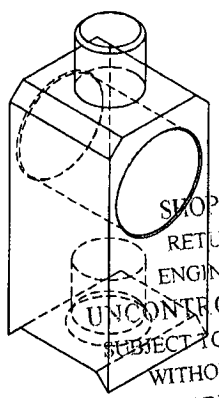
RF	RE		
CHECKED	APPROVED	DRAWING NO. D3353	REV. A SHEET 10 OF 10
DATE 04.12.14		TITLE LUG WELDMENT	SCALE 1:1

RELEASED
06/03/69



D3353-17 SUPPORT



NOTES:

1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 1.50 SQUARE MILD STEEL BAR (REF. DART SPEC. M1010-B1.500x01.500)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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